

Work Order ID 121379

Thursday, June 26, 2014 2:58:13 PM

121379

Page 1

Item ID: D4868-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Leg Assembly
Start Date: 6/26/14 Start Qty: ~~3.00~~ ***3*** Cust Item ID:
Required Date: 6/26/14 Req'd Qty: 3.00 ***3*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 140627 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4868	<u>2 Cu</u>								

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ALIGN PILOT HOLES IN D4868-1 WITH PILOT HOLES IN D4871-1 AND
D4871-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9965 AS PER DWG.

2 FF DEC 16 2014

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

(2) DAS
38
9-89

DEC 16 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 1501-23

15-1-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Thursday, June 26, 2014 2:58:12 PM

121379

D4868-042

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4868-1		Manufactured	No				Each	0.0000		3			
D4868-1					121389				**	2	FF	DEC 16 2014	
Strut													
D4871-1		Manufactured	No				Each	3.0000		3			
D4871-1									**		FF	DEC 16 2014	
End Fitting													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST124	123389		3			2			
					112018		3						
D4871-3		Manufactured	No				Each	3.0000		3			
D4871-3									**		FF	DEC 16 2014	
End Fitting, Eye													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST124	123526		3			2			
					117329		3						
HL20PB5-12		Purchased	No				Each	180.0000		12			
HL20PB5-12									**		FF	DEC 16 2014	
Rivet													
HL 32PB5-12													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST265	1129912		180			8			
					M128110		38						
					M128973		142						

DQA: _____ Date: _____



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Picklist Print

Thursday, June 26, 2014 2:58:12 PM

Work Order ID: 121379

121379

Parent Item: D4868-042

D4868-042

Parent Item Name: 206L Leg Assembly

Start Date: 6/26/14

Required Date: 6/26/14

Start Qty: 3.00

Required Qty: 3.00

HL86-5

Purchased

No

Each

241.0000

12

HI 86-5

FF

DEC 16 2014

Collar

Location

Loc Qty

Loc Code

ST263

01/29/2014

241

M128110

12

M128228

29

M129022

200

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO26854**

Purchase Order Date 12/18/2014

PO Print Date 12/18/2014

Page Number 1 of 3

Order From :

VC-PL001

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect



Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Pri
1	117156	D4804-041 BIPOD ASSEMBLY	12/23/2014 Yes 12/23/2014		1.00	\$4.00	\$4.00
	LASER MARKED						
						Line Total:	\$4.00
2	121379	D4868-042 LEG ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00 ✓	\$4.00	\$8.00
	LASER MARKED						
						Line Total:	\$8.00
3	117021	D4803-041 BAR ASSEMBLY	12/23/2014 Yes 12/23/2014		2.00	\$4.00	\$8.00
	LASER MARKED						

SP15-01-20

Note:

12/18/2014



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE January 14, 2015

P.O NUMBER PO26854

ITEM DESCRIPTION**QUANTITY****COMMENTS**

D4804-041 BIPOP ASSEMBLY

1

ALL ITEMS HAVE BEEN LASER MARKED

D4868-042 LEG ASSEMBLY

2

D4803-041 LEG ASSEMBLY

2

D4868-041 LEG ASSEMBLY

2

D4834-042 LEG ASSEMBLY

2

Handwritten signature and initials



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7524

Date: January 14, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
26854		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4804-041	1.00	4.00	✓	4.00
Laser Metal Marking, D4868-042 ✓	2.00	4.00	✓	8.00
Laser Metal Marking, D4803-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4868-041	2.00	4.00	✓	8.00
Laser Metal Marking, D4834-042	2.00	4.00	✓	8.00
Sub-Total				\$36.00
13.00% on 36.00				4.68
Total				\$40.68

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You